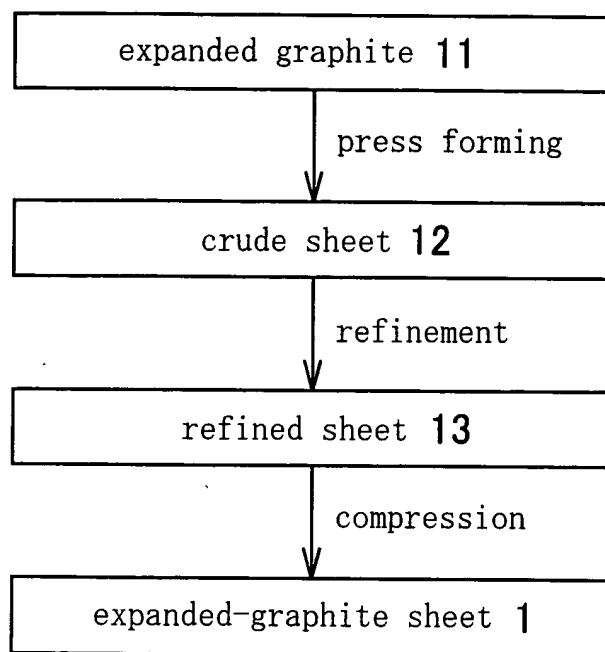
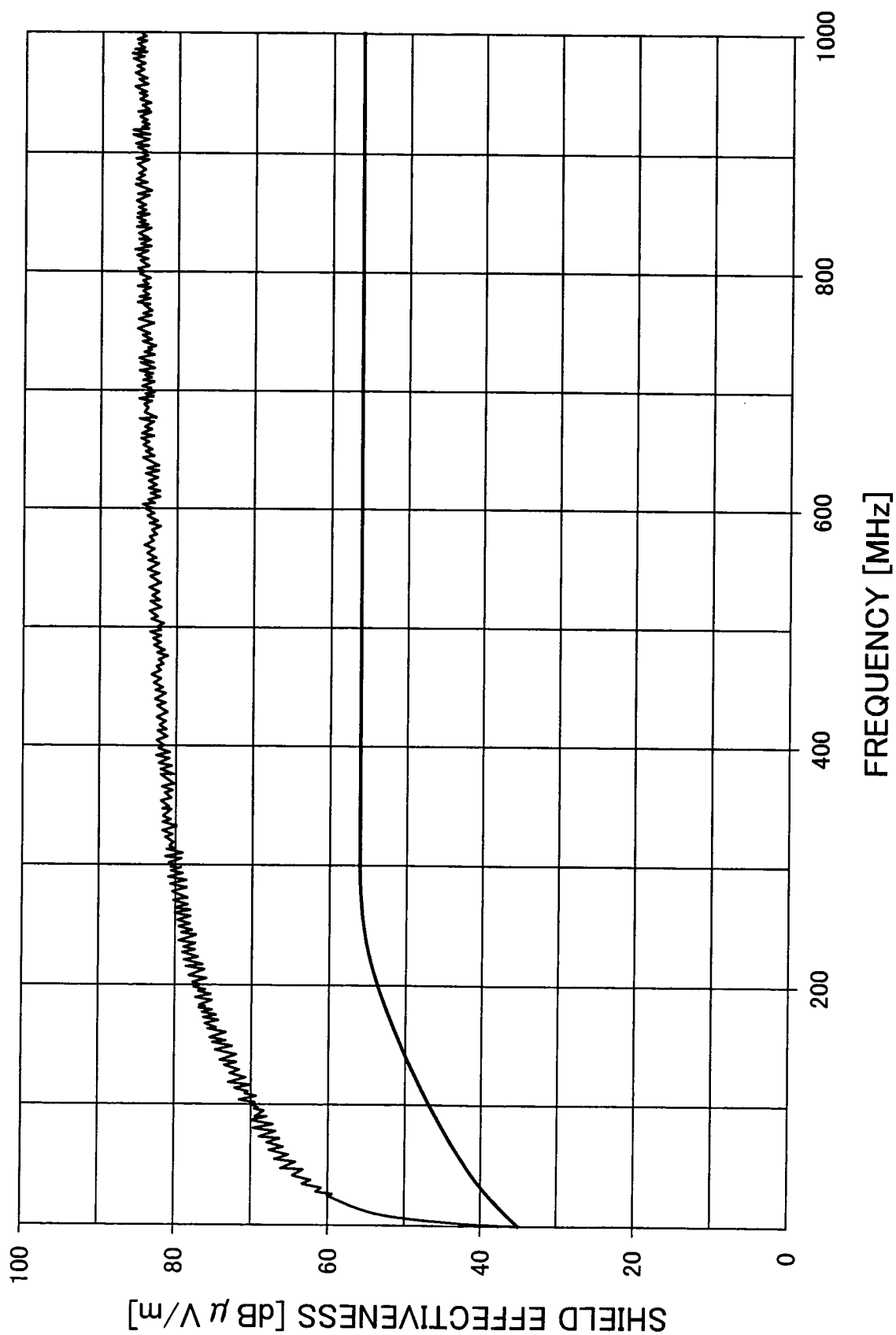


1/3
F I G. 1



2/3
FIG. 2



3/3
FIG. 3

	rolling speed (m/min)					
	1	2	4	6	8	10
creases	no creases	no creases	creases	creases	creases	creases
surface roughness center line average height Ra (μm)	2	3	5	6	6	6
$\frac{\text{Max-Min}}{\text{Ave}} \times 100 \text{ (\%)} $	5	8	14	14	22	30